

Work Order ID 154320***154320***

Page 1

Thursday, December 08, 2016 11:15:25 AM

Item ID: D4149-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Lug Plate, Aft

Start Date: 2/2/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/3/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

Date: DEC 9 2016

Tooling:

Date:

Run Start

NR1

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4149

C

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.09

Cut as per dwg D4149

Prog Rev: C

Dwg Rev: C

OPEN TO HOLES TO FINISH SIZE AS PER DWG

Deburr as required

(4)

on 12/12/14

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.01

(4)

on 12/12/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Thursday, December 08, 2016 11:15:25 AM

154320

Page 2

N900040100

NS1

Stop

NS2

4

Cust Item ID:

4

Customer:

Reference:

Date:

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Insp.
Stamp**

0.00

120

0.01

DAS
9
9-89

QC

Memo

Quality Control

0.00

150

0.01

DAS
26
9-89

JAN 03 2017

Packaging

Memo

Packaging

0.00

160

0.07

DAS
21
9-89

~~JAN 04 2017~~

QC

Memo

Quality Control

DAS
21
9-89

JAN 03 2017

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
340 35 -P									
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Picklist Print

Thursday, December 08, 2016 11:15:25 AM

Page 1

Work Order ID: 154320

154320

Parent Item: D4149-1

D4149-1

Parent Item Name: Crosstube Lug Plate, Aft

Start Date: 2/2/2017

Required Date: 2/3/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased			No	100	sf	57.8000	0.1355	0.570526			

M304S11GA

304/316 0.125 Sheet

02/16/12/14

Location

Loc Qty

Loc Code

MAT020

57.79998

M129545

0.00109

M135355

25.79889

M136327

32

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																																

DART AEROSPACE LTD		Work Order: 154320
Description: Aft Crosstube Lug Plate		Part Number: D4149-1
Inspection Dwg: D4149	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	Ø.128	1		V: D-02	
Ø0.191	+0.005/-0.001	Ø.190	1		Taper	
Ø0.257	+0.006/-0.001	Ø.256	1			
Ø0.38	+0.006/-0.001	Ø.38	1			
0.380	+/-0.010	.384	1			
0.469	+/-0.010	.468	1			
0.310	+/-0.010	.308	1			
0.750	+/-0.010	.749	1			
3.25	+/-0.030	3.25	1			
0.65	+/-0.030	.65	1			
0.63	+/-0.030	.63	1			
5.46	+/-0.030	5.46	1			
3.80	+/-0.030	3.80	1			
2.13	+/-0.030	2.13	1			
1.313	+/-0.010	1.313	1			
0.625	+/-0.010	.625	1			
0.375	+/-0.010	.381	1			
1.175	+/-0.010	1.180	1			
0.752	+/-0.010	.755	1			
1.588	+/-0.010	1.589	1			
1.587	+/-0.010	1.588	1			
11.15	+/-0.030	11.15	1			
0.750	+/-0.010	.759	1			
1.55	+/-0.030	1.55	1			
1.12	+/-0.030	1.12	1			
8.42	+/-0.030	8.42	1			
2.70	+/-0.030	2.70	1			
0.125	+/-0.010	.116	1			
Ø0.252	+0.003/-0.000	Ø.252	1			

Measured by: DC	Audited by: DAS 9	Preliminary Approval:
Date: 16/12/19	Date: 17-01-05	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	12.02.01	Dimensions updated per Dwg Rev C	KJ	

